

Work Order ID 55356

January 13, 2010 2:46:02 PM



Page 1

Item ID: D3947-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Upper RH Post

Start Date: 1/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/19/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *PL*

Date: 10-1-13

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

DL 10/01/13 (x1)

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D36476-1 and Folio FTA 045 using tool DT9483:

Dwg. Rev. *A*

Folio Rev. *A*

DL 10/01/13 (x1)

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Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

DL 10/01/13 (X9)

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

BB 10/01/14 (X1)

140

HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3946-1

DL 10/01/14 (X10) ATO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3947-2 PAR #: N/A Fault Category: Thermo. NCR: Yes No DQA: 10/01/20 Date: 10/01/20
 Resolution: acceptable Disposition: Use as-is QA: N/C Closed: 10/01/26 Date: 10/01/26

NCR: <u>55356</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.01.14	140	EDGE DISTANCE ON ONE FLANGE IS 0.183" DWG SAYS 0.2 MIN	GP 10.01.14 per (QSI) 042	Acceptable. PART IN A/C REQUIRES FURTHER TRAMMING (0.12"). LOAD TEST PULLED MUCH HIGHER	OK 10/01/14	8 10/01/14	GP 10.01.14 per (QSI) 042	8 10/01/15
10.01.14	140	↓	GP 10.01.14	THAN REQ'D ↓			GP 10.01.14	8 10/01/15
		RC: 'used after'						

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 1/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

OK 10/01/14 (K1)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ Solobles

(K)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

10-1-18 of (K)

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Accept

Setup Start

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Stop

Item Name: Panel, Upper RH Post

Start Date: 1/13/10 Start Qty: 1.00

Cust Item ID:

Required Date: 1/19/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/19 JG
MF 10-1-18

Picklist Print

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Page 1

Work Order ID: 55356



Parent Item: D3947-2



Parent Item Name: Panel, Upper RH Post

Start Date: 1/13/10

Required Date: 1/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	749.8927	3.4795			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	749.8926526	
107574	16.62	
111973	190.526053	
112176	542.7466	

3.3056 sqft. OK 10/01/13 (X1)

DART AEROSPACE LTD		Work Order:	55356
Description: Panel, Upper RH		Part Number:	D3947-2
Inspection Dwg: D3947	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: *DL*

Date: 10/01/14

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.0	Min	10.0	✓			
0.2	Min	1.183		✓	Vern.	Dimension (See NCR)
0.5	Min	1.583	✓			
1.8	Min	1.847	✓			
3.1	REF	3.169	✓			
26.6	REF	26.875	✓			
0.050	Min	0.058	✓			
0.070	Min	0.077	✓			

Measured by: *DL*

Date:

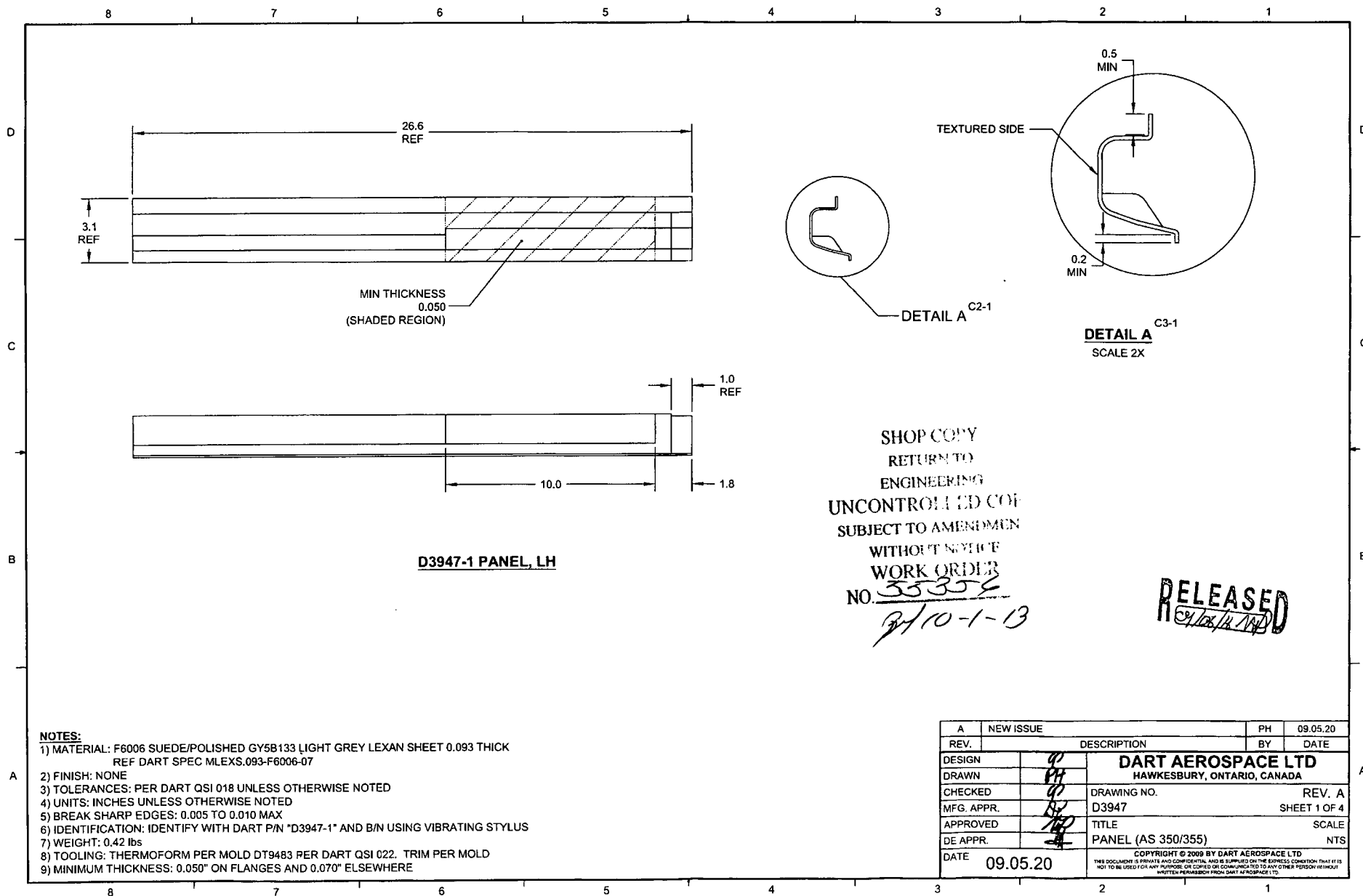
Audited by: *JB*

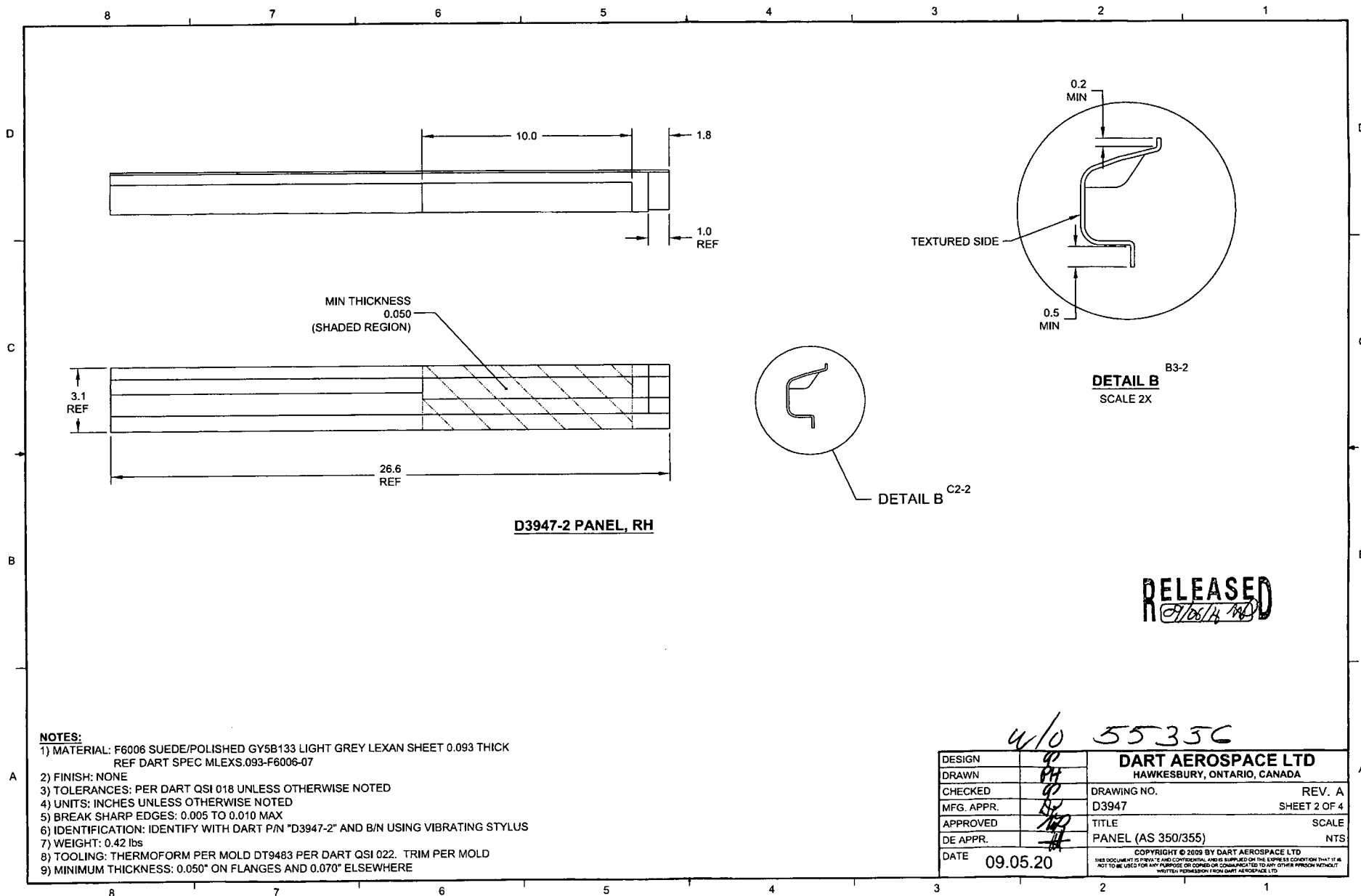
Date: 10/01/14

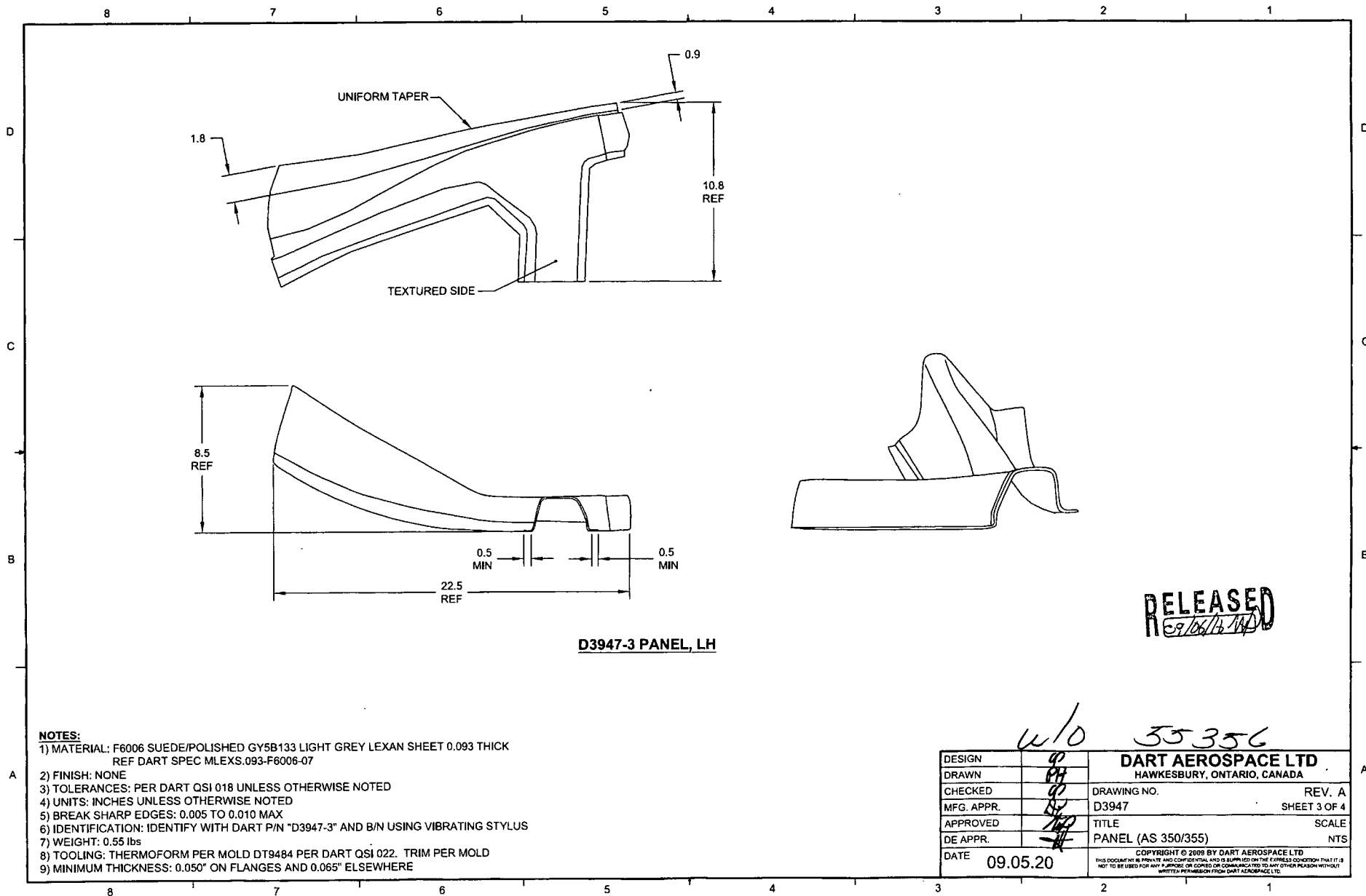
Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<i>[Signature]</i>





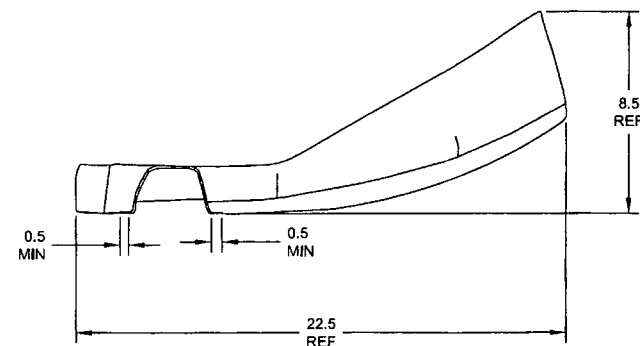
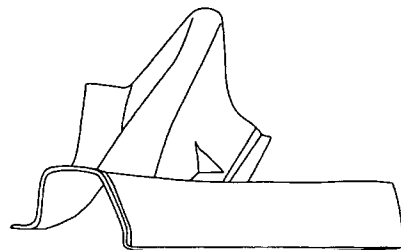
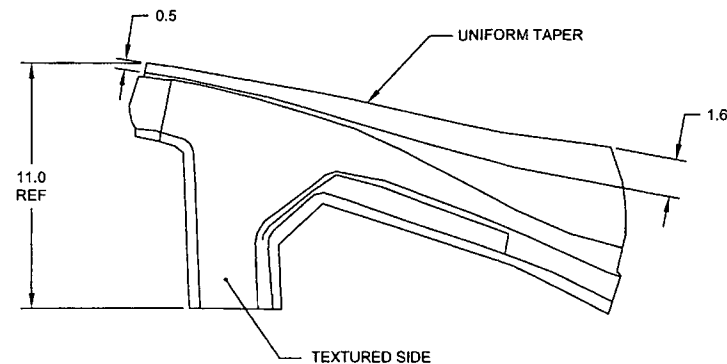


RELEASED
09/06/14

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-3" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.55 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	W/O	35356	
DRAWN	PH	DART AEROSPACE LTD	
CHECKED	PH	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	PH	DRAWING NO. D3947	REV. A SHEET 3 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	PANEL (AS 350/355)	NTS
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D3947-4 PANEL, RH

RELEASED
09/04/00

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3947	SHEET 4 OF 4
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